
वस्त्रादि — हथकरघा निर्मित सूती ग्रे,
धारीदार व चौखानेदार स्पंज कपड़ा — विशिष्टि
(दूसरा पुनरीक्षण)

**Textiles — Handloom Cotton Sponge
Cloth, Grey, Striped or Checked —
Specification**
(*Second Revision*)

ICS 59.080.30

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FOREWORD

This Indian Standard (Second Revision) was adopted by the Bureau of Indian Standards, after the draft finalized by the Handloom and Khadi Sectional Committee had been approved by the Textiles Division Council.

This standard was first published in 1956 and subsequently revised in 1987. This standard has been again revised to incorporate the following major changes:

- a) Requirement and test method for identification of material has been incorporated;
- b) Amendment has been incorporated;
- c) Sampling plan has been modified;
- d) References to Indian Standards have been updated; and
- e) BIS certification marking clause has been updated.

The composition of the Committee responsible for the formulation of this standard is given in Annex B.

For the purpose of deciding whether a particular requirement of this standard is complied with the final value, observed or calculated, expressing the result of a test or analysis shall be rounded off in accordance with IS 2 : 1960 'Rules for rounding off numerical values (*revised*)'. The number of significant places retained in the rounded off value should be the same as that of the specified value in this standard.

Indian Standard

TEXTILES — HANDLOOM COTTON SPONGE CLOTH, GREY, STRIPED OR CHECKED — SPECIFICATION

(Second Revision)

1 SCOPE

1.1 This standard prescribes the constructional particulars and other requirements of three varieties of handloom cotton sponge cloth, grey, striped or checked.

1.2 This standard does not specify the general appearance, lustre, feel, finish or colour and their combination in striped or checked cloth.

2 REFERENCES

The standards listed in Annex A contain provisions which through reference in this text, constitute provision of this standard. At the time of publication, the editions indicated were valid. All standards are subject to revision, and parties to agreements based on this standard are encouraged to investigate the possibility of applying the most recent editions of the standards indicated in Annex A.

3 MANUFACTURE

3.1 Yarn — The cotton yarn used in the manufacture of cloth shall conform to the requirements of IS 171.

3.1.1 The warp yarn shall not be sized before weaving.

3.2 Cloth — Each cut end of the sponge cloth shall be hemmed to a depth of not less than 1 cm, the raw edges having a turn in of 10 mm before the hem is formed. Cotton sewing thread conforming to variety number 31 of IS 1720 shall be used in hemming and number of stitches shall be at least 40 per decimetre.

4 REQUIREMENTS

4.1 The cloth shall conform to the constructional requirements and other characteristics as given in Table 1 and Table 2.

4.2 If in order to illustrate or specify the indeterminable characteristics, such as general appearance, lustre, feel, and shade of the cloth, a sample has been agreed upon and sealed, the supply shall be in conformity with the sample in such respects.

4.2.1 The custody of the sealed sample shall be a matter of prior agreement between the buyer and the seller.

Table 1 Constructional Particulars of Handloom Cotton Sponge Cloth, Grey, Striped or Checked

(Clause 4.1)

Variety No.	Count of Yarn, Universal Count (Cotton Count)		Ends/dm	Picks/dm	Weight, g/m ²	Length	Width	Weave
	Warp	Weft						
(1)	(2)	(3)	(4)	(5)	(6)	(7)	(8)	(9)
1	295 tex (2 ^s)	295 tex (2 ^s)	50	50	315	As agreed, <i>see</i> Note	↑ ↓	2/2 twill
2	60 tex × 2 (10 ^s /2)	394 tex (1.5 ^s)	50	70	390			2/2 twill
3	30 tex × 2 (20 ^s /2)	148 tex (4 ^s)	40	30 (double)	270			One and one leno
Tolerance, percent	±5	±5	±5	±5	±5	−2	−2	—
Method of test	IS 3442	IS 3442	IS 1963	IS 1963	IS 1964	IS 1954	IS 1954	Visual

NOTE — The usual width and corresponding length of sponge cloth are given below:

Width, cm	Length, cm
18	18
18	21
21	21

Table 2 Requirements of Handloom Cotton Sponge Cloth, Grey, Striped or Checked
(Clause 4.1)

SI No. (1)	Characteristic (2)	Requirement (3)	Method of Test, Ref to (4)
i)	Identification of material (<i>see</i> Note)	100 percent cotton	IS 667
ii)	Colour fastness (for striped or checked cloth only):		IS/ISO 105-B01
	a) Light (Change in colour)	4 or better	IS/ISO 105-B02
	b) Washing: Test D (4)		IS/ISO 105-C10
	1) Change in colour	4 or better	
	2) Staining on cotton	4 or better	
iii)	Scouring loss, percent, max	5	IS 1383

NOTE — Impurities of less than 0.2 percent shall be permitted.

5 INSPECTION

5.1 The cloth when visually inspected should be reasonably free from the following defects:

- Weft crack or more than two missing picks across the width;
- Prominently noticeable weft bar due to the difference in raw material, count, twist, lustre, colour, shade, etc;
- More than two adjacent ends running parallel, broken or missing and extending beyond 15 cm;
- Prominent selvedge defects;
- Noticeable warp or weft float;
- Noticeable hole, cut or tear up to 3 mm in size;
- Noticeable oil or other stains;
- Smash rupturing the texture of the fabric; and
- Prominently noticeable dyeing defects (bars, streaks and patches, etc).

5.1.1 A reference may be made to IS 14466 for details of these defects.

6 MARKING

6.1 The cloth shall be suitably marked or labelled with the following information:

- Name of the material and variety no.;
- Manufacturer's name, initials or trade-mark;
- Length (cm) and width (cm);
- Month and year of manufacture; and
- Any other information as required by the buyer or the law in force.

6.2 BIS Certification Marking

The sponge cloth conforming to the requirements of this standard may be certified as per the conformity assessment schemes under the provisions of the *Bureau of Indian Standards Act, 2016* and the Rules and Regulations framed thereunder, and the sponge cloth may be marked with the Standard Mark.

7 PACKING

Unless otherwise agreed upon by the buyer and the seller, the cloth shall preferably be packed in bales or cases in conformity with the procedure laid down either in IS 1347 or IS 293.

8 SAMPLING

8.1 Lot

The quantity of the handloom cotton sponge cloth of the same variety delivered to one buyer against one dispatch note shall constitute a lot.

8.2 The conformity of the lot to the various requirements specified in the standard shall be determined on the basis of tests carried out on the samples selected from the lot.

8.3 Unless otherwise agreed, the number of pieces selected at random for inspection shall be in accordance with the Table 3.

8.3.1 For selection of samples at random from the lot, procedure given in IS 4905 may be followed.

Table 3 Sample Size and Permissible Number of Non-Conforming Pieces
(*Clauses 8.3 and 8.4*)

Lot Size	Sample Size	Permissible Number of Non-Conforming Sponge Cloth	Sub-Sample Size
(1)	(2)	(3)	(4)
Up to 90	5	0	3
91 to 150	8	0	3
151 to 500	13	1	5
501 to 1 200	20	1	5
1 201 to 10 000	32	2	8
10 001 to 35 000	50	3	8
35 001 to 5 00 000	80	5	13
5 00 001 and above	125	7	13

8.4 Number of Samples and Criteria for Conformity

<i>Characteristic</i>	<i>Number of Samples</i>	<i>Criteria of Conformity</i>
Count of yarn, ends, picks, length, width, weave and visual inspection	According to column 2 of Table 3	Number of non-conforming pieces shall not exceed the corresponding number given in column 3 of Table 3
All other requirements	According to column 4 of Table 3	All the test pieces shall meet the requirement

ANNEX A

(Clause 2)

LIST OF REFERRED INDIAN STANDARDS

<i>IS No.</i>	<i>Title</i>	<i>IS No.</i>	<i>Title</i>
171 : 1993	Textiles — Ring spun grey cotton yarn for weaving specification (<i>fourth revision</i>)	1963 : 2004	Methods for determination of threads per unit length in woven fabrics (<i>second revision</i>)
293 : 1980	Code for seaworthy packaging of cotton yarn and cloth (<i>third revision</i>)	1964 : 2001	Methods for determination of weight per square metre and weight per linear metre of fabrics (<i>first revision</i>)
667 : 1981	Methods for identification of textile fibres (<i>first revision</i>)	3442 : 1980	Method for determination of crimp and count of yarn removed from fabrics (<i>first revision</i>)
1347 : 1972	Specification for inland packaging of cotton cloth and yarn (<i>first revision</i>)	14466 : 1997	Fabrics — Description of defects — Vocabulary
1383 : 1977	Methods for determination of scouring loss in grey and finished cotton textile materials (<i>first revision</i>)	105-B01 : 2014	Textiles — Tests for colour fastness: Part B01 Colour fastness to light: Daylight
1720 : 1978	Specification for cotton sewing threads (<i>first revision</i>)	105-B02 : 2014	Textiles — Tests for colour fastness: Part B02 Colour fastness to artificial light: Xenon arc fading lamp test
1954 : 1990	Determination of length and width of woven fabrics — Methods (<i>second revision</i>)	105-C10 : 2006	Textiles — Tests for colour fastness: Part C10 Colour fastness to washing with soap or soap and soda

ANNEX B*(Foreword)***COMMITTEE COMPOSITION**

Handloom and Khadi Sectional Committee, TXD 08

<i>Organization</i>	<i>Representative(s)</i>
Weavers Service Centre, Delhi	SHRI VISHESH NAUTIYAL (Chairman) SHRI VIKAS KUMAR (<i>Alternate</i>)
All India Handloom Fabrics Marketing Cooperative Society Ltd, Delhi	SHRI R. UTHAMANI SHRI SHRIKANT (<i>Alternate</i>)
Association of Corporations of Apex Societies of Handlooms, Delhi	SHRI ABDUL REHMAN SHRI ANIL KUMAR SINGH (<i>Alternate</i>)
Baster Adimjati Sewak Sangh, Baster	SHRI SUMIT DAS SHRI AMIT DAS (<i>Alternate</i>)
Commissioner Handloom & Textiles, Himachal Pradesh	REPRESENTATIVE OF COMMISSIONER & DIRECTOR OF INDUSTRIES
CRPF, New Delhi	SHRI RANDHIR KUMAR JHA SHRI D. N. LAL (<i>Alternate</i>)
Department of Handlooms & Textiles, Chennai	DR M. KARUNAKARAN SHRI K. KARNAN (<i>Alternate</i>)
Directorate of Handloom & Textiles, Madhya Pradesh	DIRECTOR SHRI MAHESH GULATI (<i>Alternate</i>)
Haryana Khadi Gramodyog Sangh, Karnal	SHRI PAWAN GARG SHRI R. S. YADAV (<i>Alternate</i>)
Indian Institute of Handloom Technology, Jodhpur	DR J. SIVAGNANAM
Indian Institute of Handloom Technology, Varanasi	DR P. THENNARASU
Indo Tibetan Border Police, New Delhi	SHRI RAJESH NAINWAL SHRI ANAND KUMAR (<i>Alternate</i>)
J & K Handloom Development Corporation Ltd, Jammu Tawi	MANAGING DIRECTOR SHRI VINOD KAUL (<i>Alternate</i>)
Jan Sewa Ashram, Aligarh	SHRI R. K. SHARMA SHRI AKHILESH KUMAR AWASTHI (<i>Alternate</i>)
Khadi & Village Industries Commission, New Delhi	SHRI V. K. NAGAR SHRI RAM NARAYAN (<i>Alternate</i>)
Khadi Dyers & Printers, Mumbai	SHRI D. N. BHATT SHRI V. D. JOSHI (<i>Alternate</i>)
Khadi Gramodyog Mandal, Rampur	SHRI RAKESH CHAUDHARY SHRI PRINCE CHAUDHARY (<i>Alternate</i>)
Kshetriya Khadi Gramodyog Samiti, Dausa	SHRI R. K. SINGH
Metpalli Khadi Gramodyog Pratisthan, Telangana	SHRI G. MADHAV
Ministry of Defence (DGQA), New Delhi	SHRI M. H. BASAVRAJ SHRI N. SENTHIL KUMAR (<i>Alternate</i>)
National Handloom Development Corporation Ltd, Greater Noida	DR SAKTHIVEL PERUMAL SAMY SHRI JITENDRA TOLAMBIYA (<i>Alternate</i>)
Northern India Textile Research Association, Ghaziabad	DR M. S. PARMAR

<i>Organization</i>	<i>Representative(s)</i>
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Rastriya Khadi Gramodyog Federation, Moradabad	SHRI ANIL KUMAR SINGH SHRI KULDEEP SINGH (<i>Alternate</i>)
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Swastik Gramodyog Samiti, Delhi	SHRI M. L. PATHAK SHRI ABHISHEK DIXIT (<i>Alternate</i>)
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The Tamil Nadu Handloom Weavers' Cooperative Society Ltd, Chennai	SHRI T. N. VENKATESH SHRI K. KATHIRESAN (<i>Alternate</i>)
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Member Secretary

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SCIENTIST 'E' (TEXTILES), BIS

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